








# Work Order ID 65245

January 10, 2011 10:01:50 AM


Page 1

Item ID: D4205-1 Accept  Setup Start   
 Revision ID: PRELIM Stop   
 Item Name: Solenoid Spacer  
 Start Date: 1/10/11 Start Qty: 2.00  Cust Item ID:  
 Required Date: 1/28/11 Req'd Qty: 2.00  Customer:  
 Reference:

Approvals: Process Plan: CL Date: 11/01/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4205	<u>PA1</u> <u>PA2</u> <u>11-01-13</u>


100	FLOW WATER JET	0.00							
 Waterjet	Memo	0.00							
FLOW CNC Waterjet <u>304.050</u>	1-Cut as per Dwg Dwg Rev: <u>PA2</u> Prog Rev: _____ 2-Deburr as required								

11-1-19  
11-3-28

(2)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									

11-1-19  
11-3-28 F(4)

120	QC8- Inspect parts - second check	0.00							
 QC	Memo	0.00							
Quality Control									

POSITIVE  
RECALL

inspect to spec  
Dwg only  
8/10/11 (2)

PRELIMINARY ISSUE

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

# Work Order ID 65245

January 10, 2011 10:01:50 AM



Page 2

Item ID: D4205-1 Accept

Revision ID: PRELIM

Item Name: Solenoid Spacer

Start Date: 1/10/11 Start Qty: 2.00

Required Date: 1/28/11 Req'd Qty: 2.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*R 11-de-9  
②  
Eash*

POSITIVE RECALL

EFFECTIVE 1/10/11 AUTH W

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

# Picklist Print

Page 1

January 10, 2011 10:01:50 AM

Work Order ID: 65245

Parent Item: D4205-1

Parent Item Name: Solenoid Spacer


Start Date: 1/10/11

Required Date: 1/28/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	56.6200	0.01	0.021053			

HB11-1-12

Location	Loc Qty	Loc Code
MAT	30	
116135	30	
MAT20	26.62	
111743	4.75	
113062	20.77	
115389	1.1	
112178	S.	

2

112178 F HB11-3-28 ④

DART AEROSPACE LTD		Work Order: 65245
Description: Solenoid		Part Number: D4205
Inspection Dwg: D4205-1, Rev: PA2		Page 1 of 1

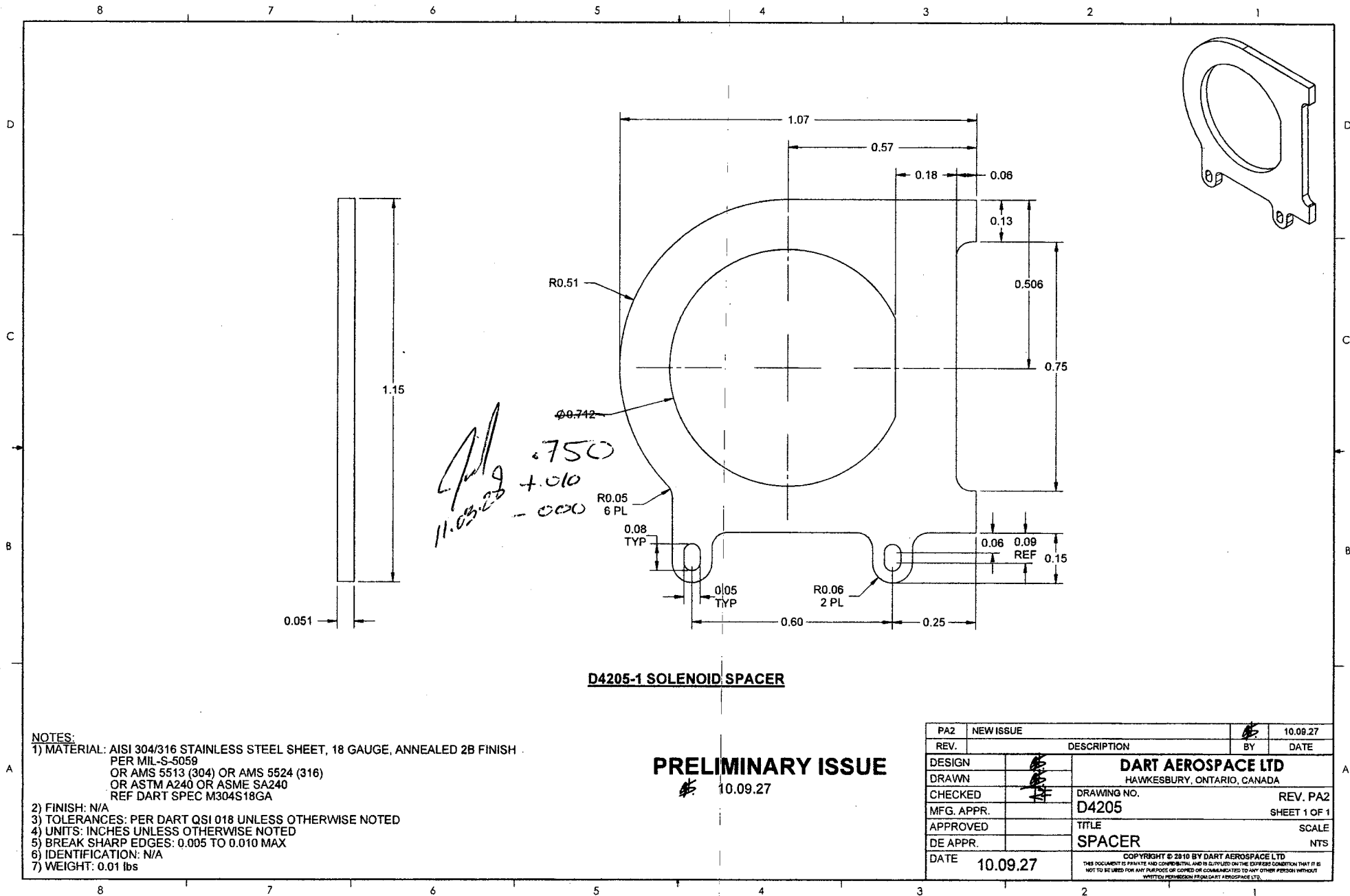
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.07	±.030	1.072	✓		V B02	
.57	±.030	.57	✓		V	
.18	±.030	.181	✓		V	
.13	±.030	.122	✓		V	
.506	±.040	.507	✓		V	
.75	±.030	.752	✓		V	
.06	±.030	.059	✓		V	
.09	±.030	.088	✓		V	
.15	±.030	.148	✓		V	
.25	±.030	.251	✓		V	
.60	±.030	.599	✓		V	
.05	±.030	.051	✓		V	
.08	±.030	.063	✓		V	
Ø 7.50	.008 - .001	7.52	✓		V	
1.15	±.030	1.149	✓		V	
.051	±.010	.047	✓		V	

Measured by: RB	Audited by:	Prototype Approval:
Date: 11-3-28	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



PA2	NEW ISSUE	10.09.27
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.09.27	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. PA2 SHEET 1 OF 1
<b>D4205</b>	SCALE NTS
<b>SPACER</b>	

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 NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

## Receiving Report

Date: 9/2/9  
 Supplier: MADNA

Batch No: M112/78  
 Dart P/O: 10030

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☒ No ☒ N/A ☐  
 QOS Inspection ☒ N/A ☐  
 Work Order 010110 N/A ☒

**Discrepancies**

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>D6202</u>		<u>20</u>	<u>0</u>	<u>0</u>	<u>20</u>	

Initials of receiver (if shipment OK) Level 12

Production/Admin: 09/07/13  
 Date RCP 10030  
 Received/Costing 02  
 Initial

Location \_\_\_\_\_



**Magna Stainless**  
5775 Kieran St, Saint-Laurent QC H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

# INVOICE

Pg 1 of 1 1014

RECEIVED

JUL 23 2009

SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY , ON  
K6A 1K7

SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY , ON  
K6A 1K7

MTR:Y

INVOICE DATE:	07/16/09
ORDER DATE:	07/09/09
SHIP DATE:	07/16/09
ORDER NUMBER:	W015570
PURCHASE ORDER:	PO10030

Currency		Sales Person		Ship Via		F.O.B.		Terms	
CANADIAN DOLLARS		ERYCK BLAIS		NIR:R-557065-1		PREPAID		NET 30 DAYS	
Ln	Back Ordered	Ordered	Unit	Description			Shipped	Price Per	Value
		1	PC	ALUMINUM - PCS 6061-T6 I-BEAM 4.00 X .326 X 25' L029408 1 PC			1 UN	695.00	

*Handwritten signature*

07/17/09 15:08:36

Merchandise:	695.00
Surcharges:	
No Tax Costs:	
GST	34.75
Total Due:	

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471  
G.S.T. # 881565899 RT0001

## Purchase Order Receipt Listing

Page 1 of 1

July 13, 2009 8:15:50 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10030 All Receipt Dates All Line Item Types  
All Item ID/GL/WOs All Rec. Employees All Currencies  
Grouped by Reference (Item, WO, GL)

Purchase Order ID	Line Nbr/Insp Req	Project ID	Vendor ID/ Name/ Currency Type	PO U/M / Stock U/M	Req Date	Req Qty	Recv Date/ Recv Emp	Recv Qty	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty	MRB Qty/ MRB Reject Qty	Book Amt
Reference: \Description				M304S18GA	304/316 .050 Sheet	112178						
PO10030	1		VC-MAG002	SF	7/08/09	160.0000	7/13/09	160.0000	\$5.00	0.0000	0	\$800.00
	No		Magna Stainless CAD	SF			LAVO01		\$800.00	0.0000	0	
								Total Received Quantity:				160.0000
								Total Quantity to Inspect (PO U/M):				0.0000
								Total Reject Quantity:				0.0000
								Total Receipt Value:				\$800.00
								Total Balance Due Quantity:				0.0000





# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

## PACKING LIST

I014049

Page: 1 of 1

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET

HAWKESBURY , ON  
K6A 1K7  
Contact: CHANTAL

HAWKESBURY , ON  
K6A 1K7  
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

STOCK

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P010030		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W015510	NET 30 DAYS L.T.		NIR:R-557065-1		07/08/09	07/09/09	07/09/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
5 ✓		PC	STAINLESS SHEET SSH 304 2B 18ga x 48" x 96"			5
			335 LB / 5 PC	L028387	SC17938	5
Skids: 1				Total Weight:		335 LB

Rec'd by: \_\_\_\_\_

Date: \_\_\_\_\_ Sign: \_\_\_\_\_

**DART**  
aerospaceDart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO10030

Purchase Order Date 7/08/09

PO Print Date 7/08/09

Page Number 1 of 1

## Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA**FAKED**  
069675

## Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

## Buyer

Requisition Nbr

Tax Resale Nbr 6122-5207

Terms Net 30

Currency CAD

FOB

## Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S18GA	304/316 .050 Sheet	7/08/09 Yes	✓ 160.00 sf	Yours ppd 10/1/9	\$5.0000	\$800.00
2	D6202P A	I Beam Extrusion	7/08/09 Yes	20.00 f	Yours ppd	\$34.7500	\$695.00

Special Inst: MATERIAL: AISI 304/316 SHEET  
ANNEALED 2B FINISH  
AS PER MIL-S-5059 OR AMS  
5513/5524 OR ASTM A240  
OR ASME SA240Special Inst: DESCRIPTION AMERICAN  
STANDARD I-BEAM  
SIZE: 4.000" X 1.796" X 0.326" THICK  
MATERIAL: 6061-T6 / T651 AS PER  
QQ-A-200/8  
MINIMUM ULTIMATE TENSILE  
STRENGTH = 38 KSI  
MINIMUM YIELD TENSILE  
STRENGTH = 35 KSIMATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

PO Total:

\$1,495.00

Change Nbr: 2

Change Date: 7/08/09

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# POSCO Mill Test Certificate/검사증명서 MO 1711 K

Certificate No./증명서번호: 080910-PRSE-010-001  
Date of Issue/발행일자: Sep., 16, 2008  
Surface Finish/표면마무리: NO.2B

Order No./계약번호: 0008353485

PO No./주문번호: 3353485

Supplier/주문자: DAE WOO INTERNATIONAL CORP.

Commodity/품명: STAINLESS COLD ROLLED COIL

Customer/고객사: MAGNA STAINLESS INC.

Spec & Type/규격: ASTM-A240-304

Size/치수	Product No./제품번호	Quantity/수량	Weight/중량 (kg)	Heat No./재질번호	P.S.T. No./P.S.T.번호	Tensile/인장강도 (MPa)	YS/항복강도 (MPa)	EL/연신율 (%)	Hardness/경도 (HRB)	Chemical Composition/화학성분 (%)
0.90x1219x0	QCH0799A	1	4,677	SE37925	T	266	649	60	82.0	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.15, Ni: 8.04, Cu: 0.02, Mo: 0.02, N: 0.004
0.90x1219x0	QCH0799B	1	4,677	SE37925	B	277	649	60	83.5	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.15, Ni: 8.04, Cu: 0.02, Mo: 0.02, N: 0.004
Sub Total (010)		2	9,354							
1.20x1219x0	QEH0031B	1	5,649	SC17938	T	281	651	60	82.3	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.11, Ni: 8.04, Cu: 0.02, Mo: 0.02, N: 0.004
1.20x1219x0	QEH0031C	1	4,190	SC17936	T	281	651	60	82.3	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.11, Ni: 8.04, Cu: 0.02, Mo: 0.02, N: 0.004
1.20x1219x0	QEH0031D	1	6,546	SC17938	B	289	651	59	84.7	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.11, Ni: 8.04, Cu: 0.02, Mo: 0.02, N: 0.004
Sub Total (020)		3	16,085							
1.50x1219x0	QEH0030A	1	5,369	SC17797	T	285	643	58	83.7	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.02, Ni: 8.03, Cu: 0.02, Mo: 0.02, N: 0.004
1.50x1219x0	QEH0030B	1	5,379	SC17797	T	285	643	58	83.7	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.02, Ni: 8.03, Cu: 0.02, Mo: 0.02, N: 0.004
1.50x1219x0	QEH0030C	1	5,225	SC17797	B	287	643	56	86.0	C: 0.025, Si: 0.03, Mn: 0.03, P: 0.004, S: 0.004, Cr: 18.02, Ni: 8.03, Cu: 0.02, Mo: 0.02, N: 0.004
Sub Total (030)		3	15,973							

Position: T: Top, M: Middle, B: Bottom

Tensile Test: Direction: Transversal, Gauge Length: 50mm (Rectangular), YP Method: 0.2% off-set

Direction: L: Ladle Analysis

Chemical Composition Unit: 2x14000, 3x14080, 4x14090, 5x140900, Tr: It is within the standard range (<0.008%) and include trace element.

We hereby certify that the material herein has been made in accordance with the order and specification.

Test Certificate is issued according to EN10204 3.1B.

This Mill Test Certificate cannot be copied for any purpose.

Surveyor To:

POSCO Pohang Works, 5 Dongchon-dong, Nam-gu, Pohang-si, Gyeongsangbuk-do, 790-785, Korea

Chief of material testing section Jo, Won C

W.G. Jo

## **CUSTOMER INFORMATION**

**DART AEROSPACE LTD**  
**1270 ABERDEEN STREET**

**HAWKESBURY, ON K6A1K7**

**Ship Date: 07/09/09**

**Ship Via: NIR-R-557065-1**

## **PRODUCT INFORMATION**

**SSH 304 2B 18ga x 48" x 96"**

**Heat: SC17938**

**Location: A6F**

**Qty: 335 LB Pcs: 5**

## **ORDER INFORMATION**

**Order No: I014049**



**Line: 0001 - Tag 1 Of 1**

**Customer PO: P010030**

**MAGNA STAINLESS INC.**

**5775 Rue Kieran Saint-Laurent, QC H4S0A8**

**07/08/09 16:18:44**

# RUSH

CE

## NOTE SHEET

**DART**  
aerospace

Project  
MPP#: 00267

Part#: D3849-047

Description: Wearplate ass'y

\*\*\*If item not required write N/A in "responsible" column\*\*\*

Item	Action required	Responsible	Due Date	Done by / Date
1	M304S18GA 0.050" thick Batch: <u>                    </u> Cut D3849-7 as per dwg	X 128 SF magna		
2	M-NEO60-S.063 black neo 0.063" batch: <u>                    </u> Cut D3848-7 as per dwg			
3	M304B0.500X2500 SS bar Batch: <u>                    </u> Cut D3901-1 as per dwg			
4	Bend wearplate as per dwg			
5	Weld as per dwg D3849			
6	QC 9 / QC 5			
7	Powdercoat gray sandtex per QSI 005			
8	QC 3			
9	Bond gasket as per dwg			
10	QC 5			
11	Identify and Stock			
12				
13				

**Chantal Lavoie**

---

**From:** Eryck Blais [eblais@magnastainless.com]  
**Sent:** July 7, 2009 1:11 PM  
**To:** 'Chantal Lavoie'  
**Subject:** RE: QUOTE

THANK YOU  
ERYCK

---

**From:** Chantal Lavoie [mailto:clavoie@dartaero.com]  
**Sent:** Monday, July 06, 2009 3:20 PM  
**To:** Eryck Blais  
**Subject:** QUOTE

Please advise price & delivery on material.  
6061-T6 I-Beam size: 4" x 2.796" x .326" thick x 20ft \$695.00 EACH DELAY 5-7 DAYS  
304 sheet 18ga x 160 sf 5 PCS \$160.00 EACH STOCK CAN DEL'D TOMMOR

Thanks

Chantal

7/07/09

**Chantal Lavoie**

---

**From:** Eryck Blais [eblais@magnastainless.com]  
**Sent:** July 7, 2009 1:11 PM  
**To:** 'Chantal Lavoie'  
**Subject:** RE: QUOTE

THANK YOU  
ERYCK

---

**From:** Chantal Lavoie [mailto:clavoie@dartaero.com]  
**Sent:** Monday, July 06, 2009 3:20 PM  
**To:** Eryck Blais  
**Subject:** QUOTE

Please advise price & delivery on material.

✱ 6061-T6 I-Beam size: 4" x 2.796" x .326" thick x 20ft \$695.00 EACH DELAY 5-7 DAYS ✱  
304 sheet 18ga x 160 sf 5 PCS \$160.00 EACH STOCK CAN DEL'D TOMMOR

Thanks

Chantal

*Standard . 4" x 3" x 3/16.*

7/07/09